

Date: Friday, 11/04/2008 11:09:36 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 38527		
Estimate Number	: 12462		
P.O. Number	:	Part Number	: D35083
This Issue	: 11/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3508 REV C
First Issue	: 11/04/2008	Project Number	: N/A
Previous Run	: 38431	Drawing Revision	: C
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 30/04/2008
Checked & Approved By	: <u>JD</u> <u>OK 4.11</u>	Qty:	12 Um: Each
Comment	: Est Rev:A New Issue 06-06-20 JLM Est Rev:B Now SS as per Rev B 06-12-15 JLM Est Rev:C Rev C dwg 07-12-06 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.7707 sf(s)/Unit Total : 9.2484 sf(s)
 304 SS .038" THK (20GA)
 (M304S20GA)
 Batch: 107744 B8-4-16 MAT NOT PULLED

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3508
 Dwg Rev: C B8-4-16
 Prog Rev: C

(12)

2-Deburr if necessary B8-4-16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Job 46 (12)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 1-Form on brake using DT8326 and DT8261 as per Dwg D3508

SB 08/04/21

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____







QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/04/2008 11:09:37 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPLATE	
Job Number: 38527		Part Number: D35083	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
2-Form joggle as per Dwg D3508 Using DT8158			
6.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP		SB 08/04/21 (12)	
7.0	POWDER COATING	POWDER COATING	
			
Comment: POWDER COATING		M 106442	
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3			
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			
Comment: INSPECT POWDER COAT		08-04-22 (X12)	
9.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1		08-04-22 (X12)	
Identify and Stock			
Location: EP-17			
10.0	QC21	FINAL INSPECTION/W/O RELEASE	
			
Comment: FINAL INSPECTION/W/O RELEASE		08/04/22	

Job Completion



U 080422

30 min
22/04/2008
S.072 07.26
#1 323.6
#2 B38527
#3 D35083
#4

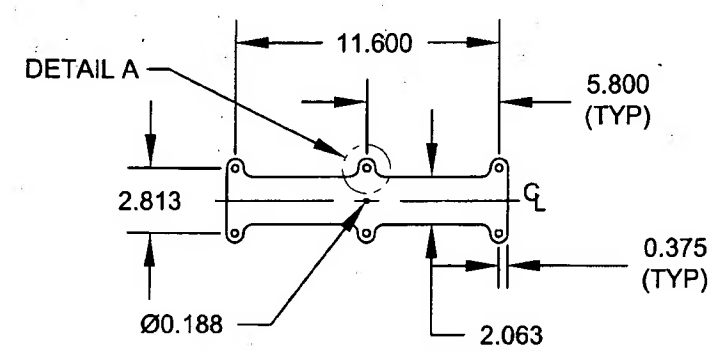
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

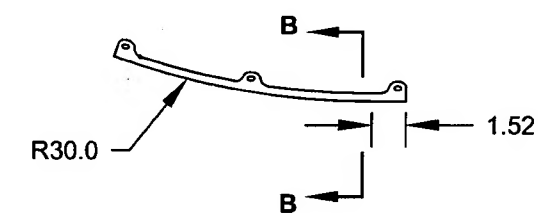
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

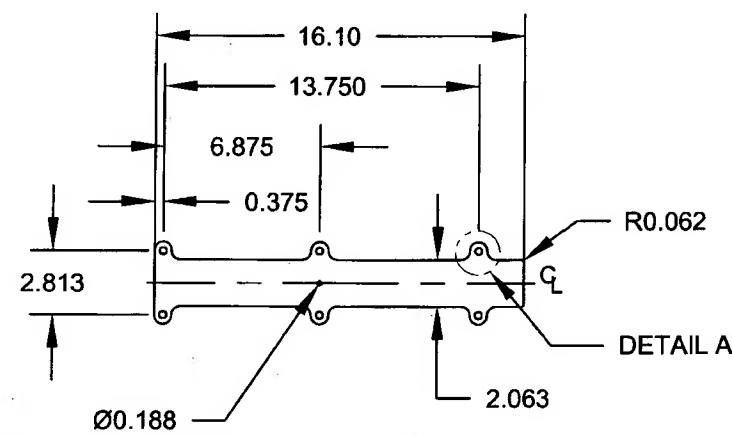
NOTE: Date & initial all entries



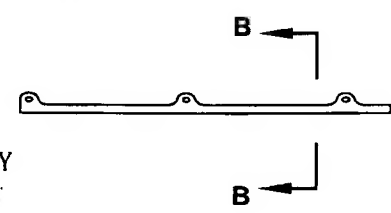
D3508-1 FLAT PATTERN



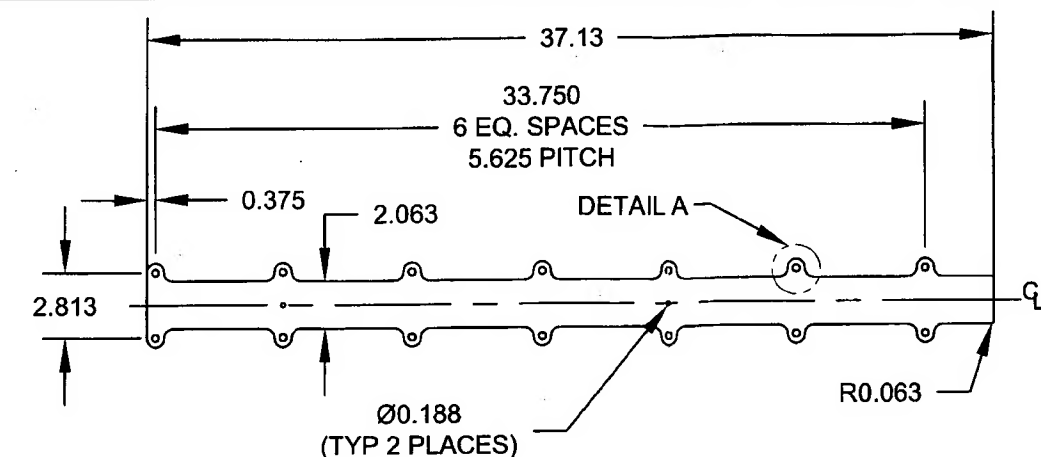
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



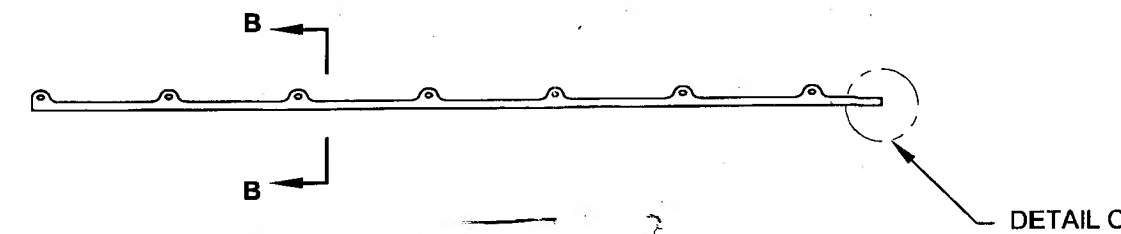
D3508-7F FLAT PATTERN



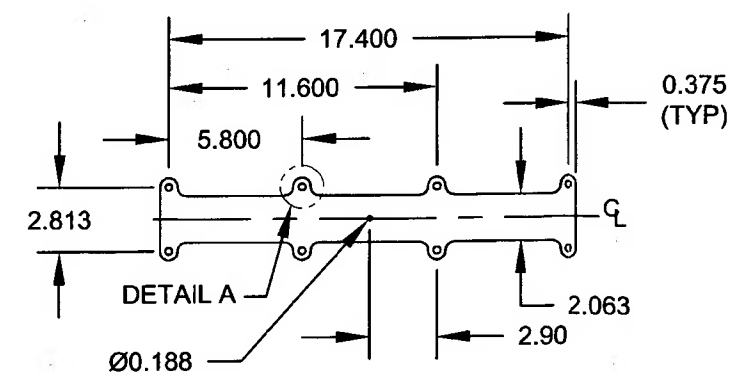
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



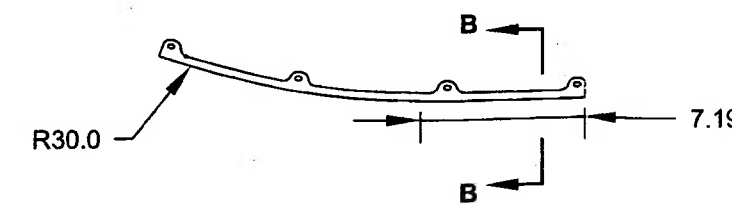
D3508-3 FLAT PATTERN



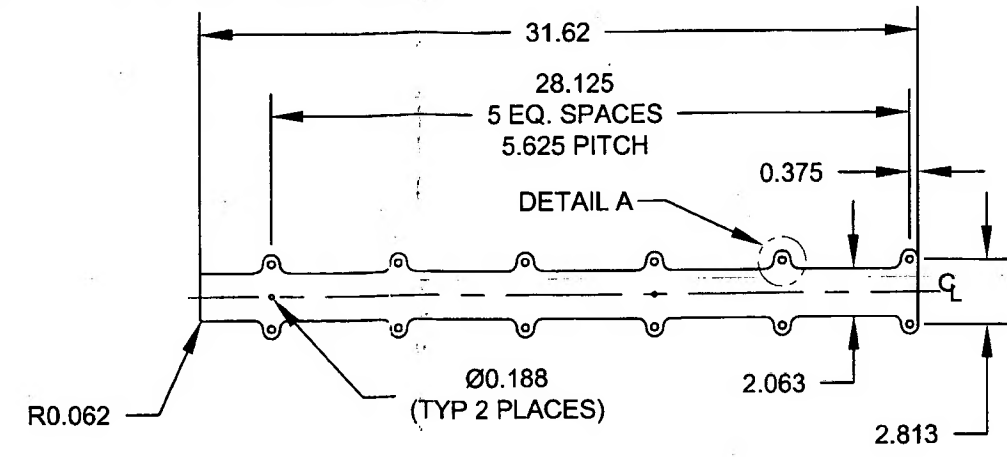
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



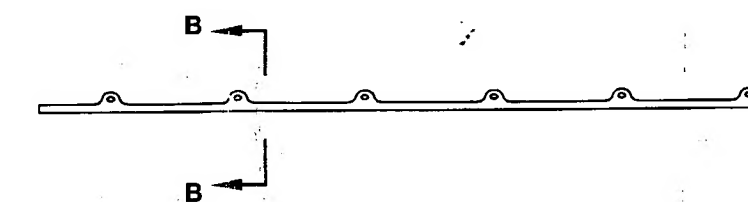
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



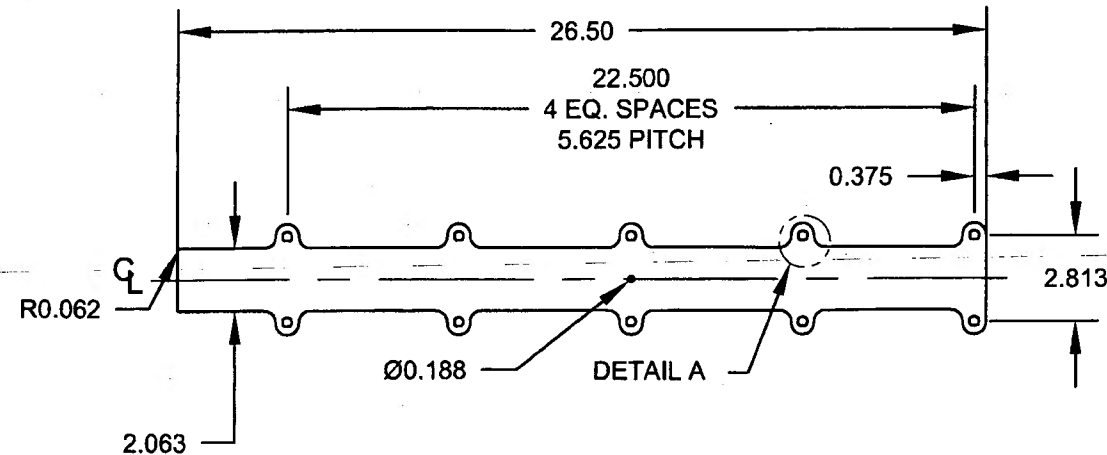
D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF. DART MATERIAL SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.015
 - 7) IDENTIFICATION: NONE
 - 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs, D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs, D3508-13 - 0.25 lbs

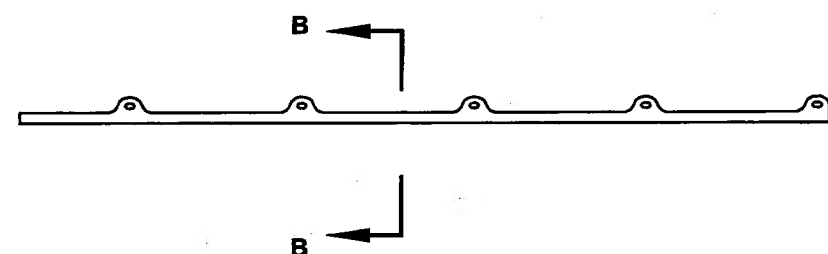
RELEASED
07.11.16

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38527

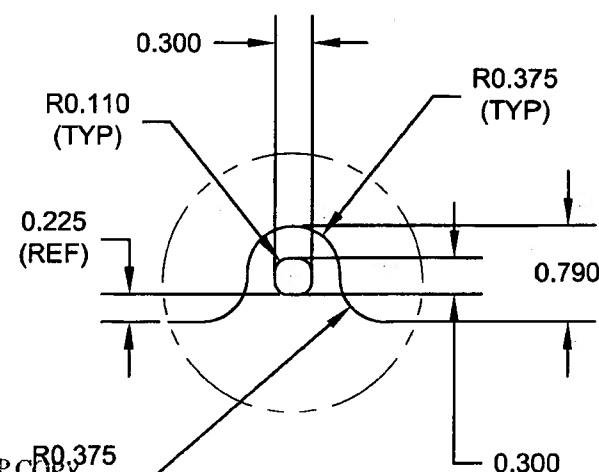
DESIGN	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
DRAWN		PH	06.10.27
CHECKED		PH	06.04.21
MFG. APPR.		BY	DATE
APPROVED			
DE APPR.			
DATE	07.04.20		
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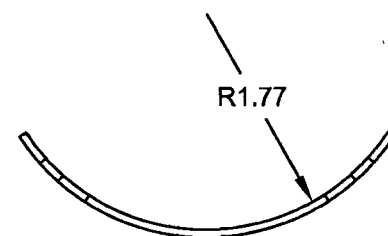
D3508-11F FLAT PATTERN



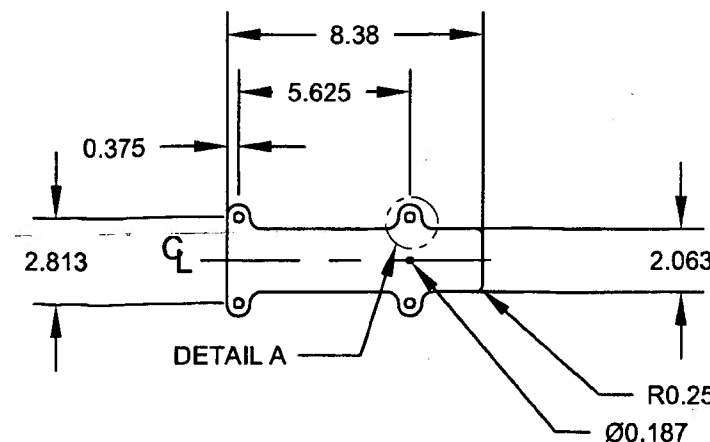
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



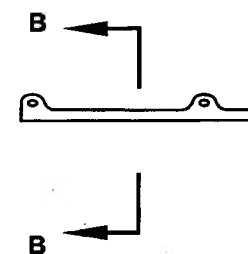
DETAIL A
(SCALE 2:3)



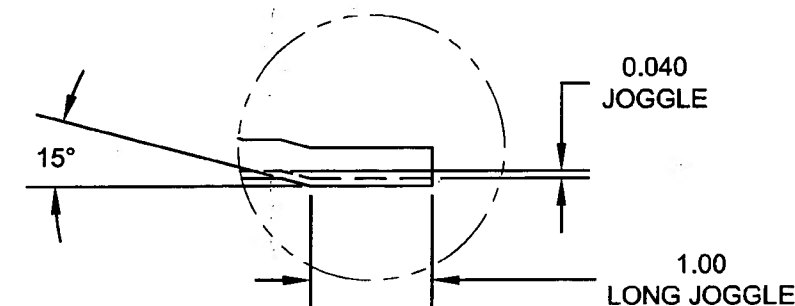
SECTION B-B
(SCALE 2:3)



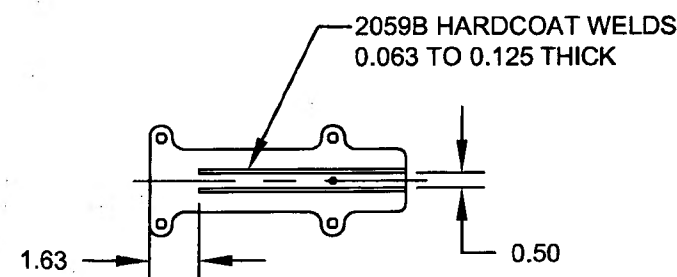
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

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WORK ORDER
NO. 38827

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DRAWN	PH	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO.	REV. C
MFG. APPR.	E	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
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